



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4016-1

Job Sheet 200377



Part No: D4016-1

Job Qty: 40 pcs

Part Name: Hinge Half, Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg
REV.A DD 10.02.22 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Bandsaw - 1	40 pcs	10/15/19		0.00	2.60	Bandsaw - 1	MM 2019/11/14
110	HAAS 4 Axis - B4B	40 pcs	10/15/19		0.03	17.17	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	MM 2019/11/14
130	QC 8	40 pcs	10/15/19		0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	

DAS
64
9-89

DAS
64
9-89

DAS
52
9-89



Container No: S231789



Part: D4016-1

Job No: 200377

Serial No/Batch: S231789

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 11/14/19

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9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 8 - 76				
160	Packaging 3-1 - Stock - B4B	40 pcs	10/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
						Packaging 3 - 2 - B4B		
						Packaging 3 - 3 - B4B		
						Packaging 3 - 4 - B4B		
						Packaging 3 - 5 - B4B		
						Packaging 3 - 6 - B4B		
						Packaging 3 - 7 - B4B		
						Packaging 3 - 8 - B4B		
						Packaging 3 - 9 - B4B		
						Packaging 3 - 10 - B4B		
						Packaging 3 - 11 - B4B	MAL	
						Packaging 3 - 12 - B4B		
						Packaging 3 - 13 - B4B		
						Packaging 3 - 14 - B4B		
						Packaging 3 - 15 - B4B		
						Packaging 3 - 16 - B4B		
						Packaging 3 - 17 - B4B		
						Packaging 3 - 18 - B4B		
						Packaging 3 - 19 - B4B		
						Packaging 3 - 20 - B4B		
						Packaging 3 - 21 - B4B		
						Packaging 3 - 22 - B4B		
						Packaging 3 - 23 - B4B		
						Packaging 3 - 24 - B4B		
						Packaging 3 - 25 - B4B		
						Packaging 3 - 26 - B4B		
						Packaging 3 - 27 - B4B		
						Packaging 3 - 28 - B4B		
						Packaging 3 - 29 - B4B		
						Packaging 3 - 30 - B4B		
						Packaging 3 - 31 - B4B		
						Packaging 3 - 32 - B4B		
						Packaging 3 - 33 - B4B		
						Packaging 3 - 34 - B4B		
						Packaging 3 - 35 - B4B		
						Packaging 3 - 36 - B4B	DAS	
						170	QC 21 - SA	40 pcs
QC 21 - SA - 70	21							
QC 21 - SA - 53	21							

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Base	0.875Inches $\pm$ 0.010	0.885 0.865		
2	Hinge Half, Base	0.250Inches $\pm$ 0.030	0.280 0.220		
3	Hinge Half, Base	0.380Inches $\pm$ 0.030 - 0.000	0.410 0.380		
4	Hinge Half, Base	0.030Inches $\pm$ 0.030	0.060 0.000	Radius	
5	Hinge Half, Base	0.130Inches $\pm$ 0.030	0.160 0.100		
6	Hinge Half, Base	0.880Inches $\pm$ 0.030	0.910 0.850		
7	Hinge Half, Base	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256	Diameter	
8	Hinge Half, Base	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
9	Hinge Half, Base	0.500Inches $\pm$ 0.030	0.530 0.470		
10	Hinge Half, Base	0.750Inches $\pm$ 0.030	0.780 0.720		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐																															
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____																													
Description Work Order Deviation				Disposition																															
Completed By				Lead hand / Supervisor																															
								QC / QA Coordinator																											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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